

Work Order ID 71618

Thursday, July 07, 2011 9:00:30 AM



Page 2

Item ID: D3199-3

Accept



Setup Start



Revision ID:

Item Name: Bracket, Fwd LH

Stop



Start Date: 7/7/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 1.00

Customer:

Reference:

shp Monday July 11



PRELIMINARY ISSI

Page 1

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Thursday, July 07, 2011 9:00:30 AM

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Stop



Start Date: 7/7/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: *u*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3199

PEL

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: *PEL*

Prog Rev: *PEL*

Deburr if required

B11-7-7

(3)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-3 PAR #: _____ Fault Category: Design NCR: ☒ Yes No DQA: ck Date: 11/07/19
11-133 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: X Date: 11-07-20

NCR: <u>71618</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>1588</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/07/19</u>	<u>30</u>	<u>PART GOING TO REZ TO REFLECT WHAT CUSTOMER WANTS. DCA MISUNDERSTANDING/NOTES NOT CLEAR.</u>	<u>[Signature]</u> <u>11/07/19</u>	<u>SCRAP + DESTROY.</u>	<u>[Signature]</u> <u>11/07/19</u>	<u>[Signature]</u> <u>11/07/19</u>	<u>[Signature]</u> <u>11/07/19</u>	<u>[Signature]</u> <u>11/07/19</u>

NOTE: Date & initial all entries

Work Order ID 71618

Thursday, July 07, 2011 9:00:30 AM



Page 3

Item ID: D3199-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd LH

Start Date: 7/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

POSITIVE RECALL

EFFECTIVE 7/7/11 AUTH W

RELEASED _____ DATE _____

MF 11-07-15

Work Order ID 71618

Thursday, July 07, 2011 9:00:30 AM

Page 4

Item ID: D3199-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket, Fwd LH

Start Date: 7/7/2011 Start Qty: 1.00

Required Date: 7/11/2011 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

Thursday, July 07, 2011 9:00:27 AM

Page 1

Work Order ID: 71618

Parent Item: D3199-3

Parent Item Name: Bracket, Fwd LH



Start Date: 7/7/2011

Required Date: 7/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD ver:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	134.1630	0.1673	0.176105			



304/316 .040 Sheet



181-7-7

Location

Loc Qty

Loc Code

MAT020

134.163

116623

0.2

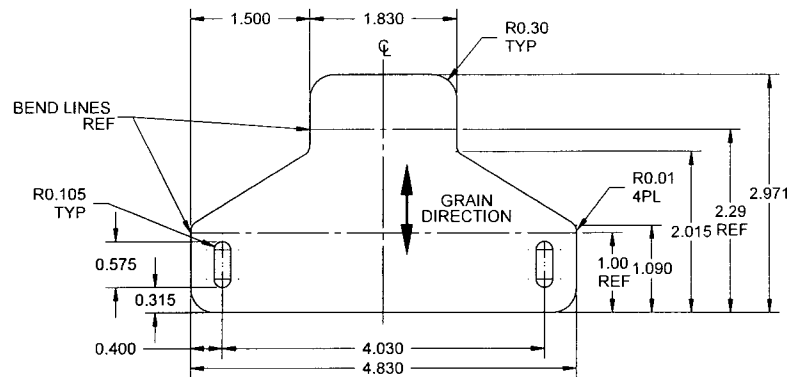
117550

9.363

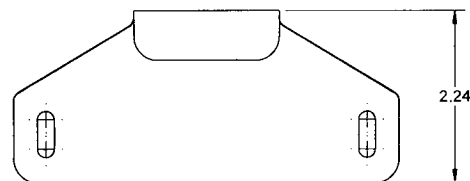
117933

124.6

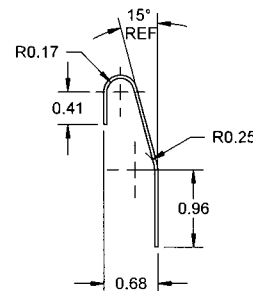
117933



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



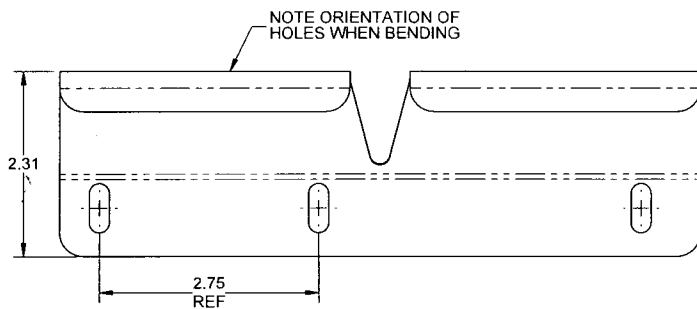
PRELIMINARY ISSUE

11.07.05

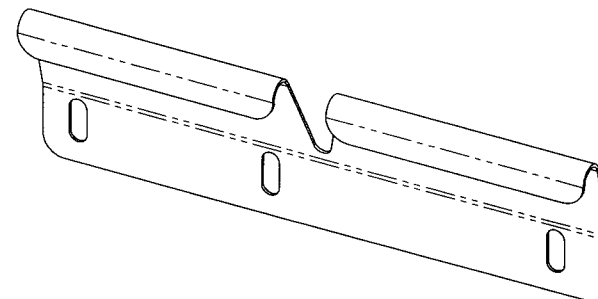
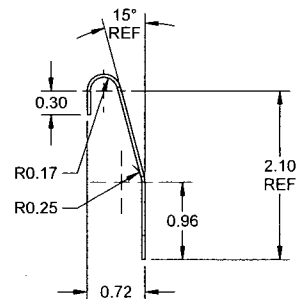
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

PE1	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.05
D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PART 1-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3199	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.05	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3199-3 BRACKET
 PE1 MADE FROM D3199-3F

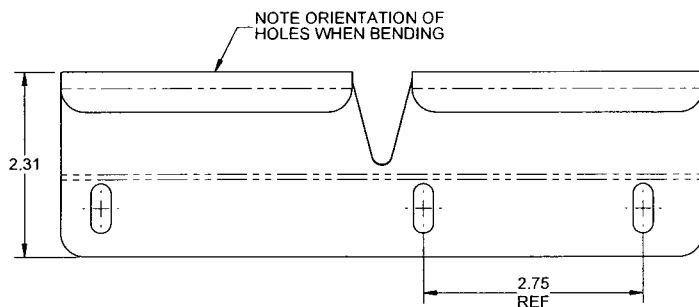


PRELIMINARY ISSUE

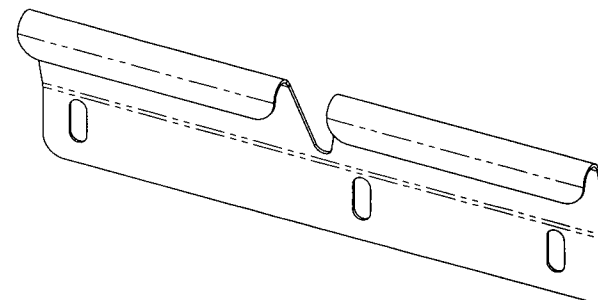
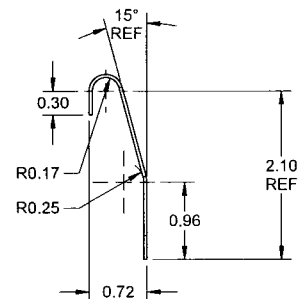
11.07.05

2/6/18

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3199	SHEET 2 OF 4
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D3199-4 BRACKET
MADE FROM D3199-3F

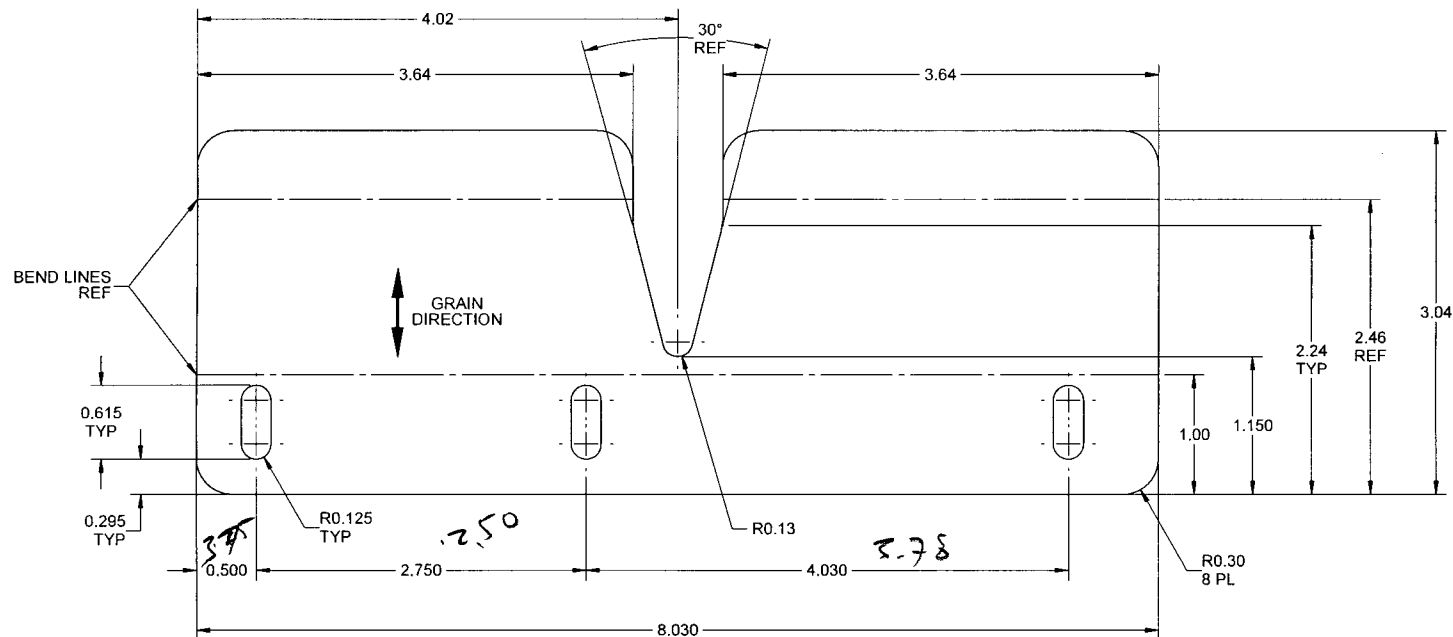


PRELIMINARY ISSUE

11.07.05

71618

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3199	SHEET 3 OF 4
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D3199-3F FLAT PATTERN

PRELIMINARY ISSUE

11.07.05

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PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN	D3199	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.07.05	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Linda Lacelle

From: Marc Bellavance <mbellavance@dartaero.com>
Sent: July 6, 2011 4:17 PM
To: Lacelle, Linda; Menard, Jean-Luc
Cc: Charbonneau, Eric; Duval, David; Shepherd, David; Petsche, Mike
Subject: D3199-3/-4/-3F Bracket


Hi Linda,

I put a copy of D3199_RevPE1 and DXF for D3199-3F here: [O:\Preliminary\D3199_RevPE1](#)

As per David, we are to make a set for DND for them to test. This should be the final tweak to this bracket.
No charge order for DSI-9484-027/-028 to follow.

Thanks,



 Please consider your
environmental responsibility
before printing this e-mail

Marc Bellavance
Technical/Shop Support
Tel: 613-632-5200 Ext. 243
Cel: 613-676-0992
Fax: 613-632-9311

Product Documentation: Verify Revision Status/Download [HERE!](#)

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DXF
JL

Linda Lacelle

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: July 7, 2011 8:43 AM
To: 'Linda Lacelle'; 'Marc Bellavance'
Cc: 'Charbonneau, Eric'; 'Duval, David'; 'Shepherd, David'; 'Petsche, Mike'
Subject: RE: D3199-3/-4/-3F Bracket

Ready to go, the prog is on Hanks prel usb.
JLM

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: July 7, 2011 6:54 AM
To: 'Marc Bellavance'; 'Menard, Jean-Luc'
Cc: 'Charbonneau, Eric'; 'Duval, David'; 'Shepherd, David'; 'Petsche, Mike'
Subject: RE: D3199-3/-4/-3F Bracket

JL, let me know when good to proceed...
LL

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: July 6, 2011 4:17 PM
To: Lacelle, Linda; Menard, Jean-Luc
Cc: Charbonneau, Eric; Duval, David; Shepherd, David; Petsche, Mike
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